

Date: Tuesday, 28/10/2008 9:00:21 AM  
 User: Melanie Fauteux

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HANDLE AND LOCK- DOWN ASSY  
 Job Number : 42995  
 Estimate Number : 13446  
 P.O. Number : Part Number : D3451041  
 This Issue : 28/10/2008 S.O. No. : Drawing Number : D3451 REVA  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : / / Type : LARGE FAB ASSY Drawing Revision : A  
 Previous Run : 42286 Material :  
 Written By : Due Date : 04/11/2008 Qty: 2 Um: Each  
 Checked & Approved By : mf 08-10-28  
 Comment : Est Rev:A 08-06-27 new issue DD verified by:ec

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D34511	Tube Handle Arm
Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) Tube Handle Arm batch: <u>342615</u> ✓ <i>Pl 08-11-11</i>		
2.0	GP211	Rubber Handle
Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) Rubber Handle batch: <u>3109006</u> ✓ <i>Pl 08-11-11</i>		
3.0	PB6743001103	Tube Handle
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Tube Handle batch: <u>341364</u> ✓ <i>Pl 08-11-11</i>		
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 1- weld as per dwg PB67-43001 <i>Pl 08-11-11</i> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">X2</span>		
5.0	QC9	VISUAL WELDING INSPECTION
Comment: VISUAL WELDING INSPECTION <i>08/11/12</i> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">2</span>		



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Job Number: 42995

Part Number: D3451041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



08-11-12 (2)



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(2X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L 08/11/12

8.0

POWDER COATING

POWDER COATING



M 102316



(2X)

Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11-30  
320 °F  
12-00

M-L 08/11/14

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

EP 08/11/17 (2)

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble rubber handle as per dwg PB67-43001

EP 08/11/17 (2)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/11/17 (2)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST

mf 08-11-17

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

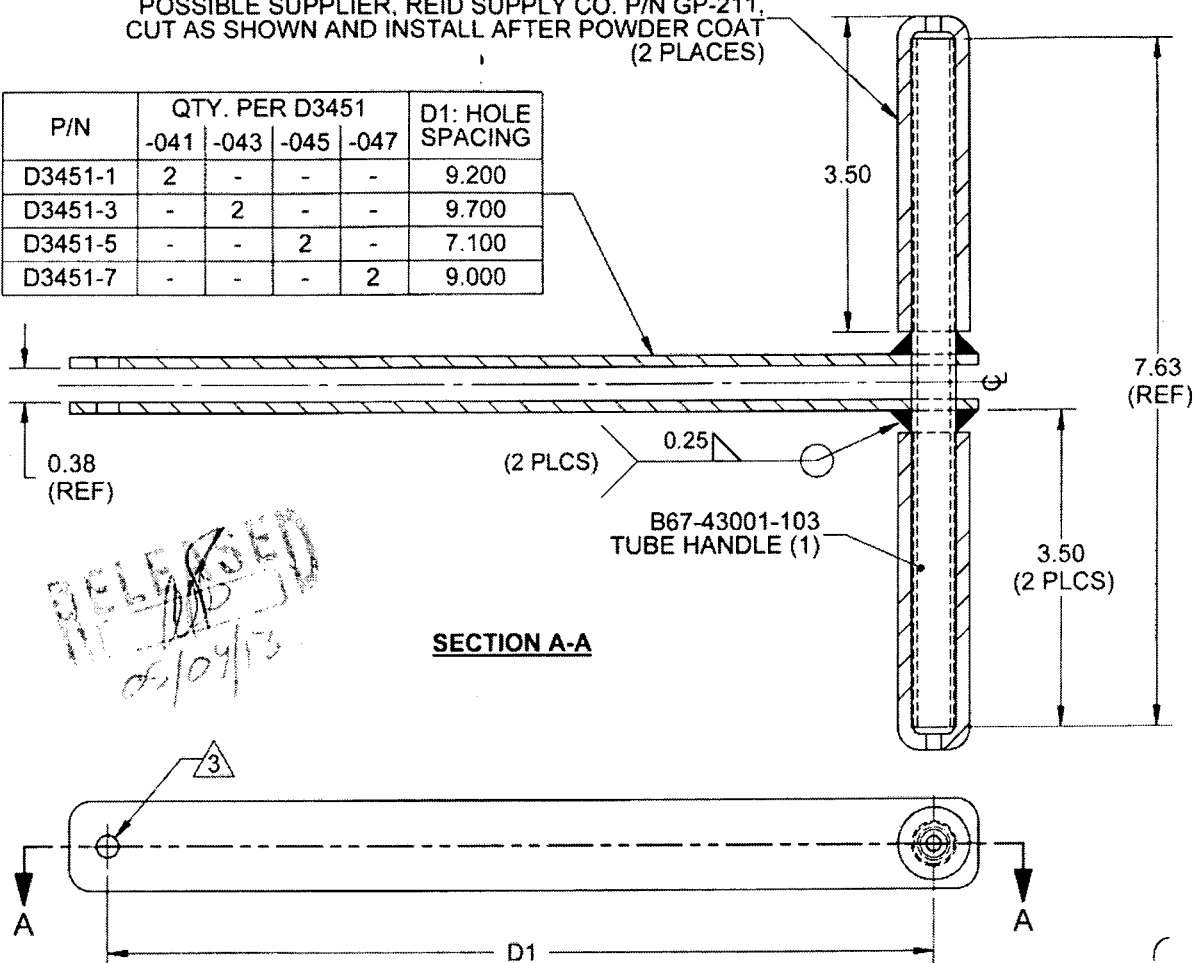
08/11/18  
mf 08-11-17



DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. <b>D3451</b>	REV. A SHEET 1 OF 2
DATE <b>05.08.25</b>	TITLE <b>HANDLE &amp; LOCK-DOWN ASS'Y</b> SCALE 1:2		
A	05.08.25	NEW ISSUE	

0.50" ID x 4.875" LONG BLACK VINYL HANDLE,  
POSSIBLE SUPPLIER, REID SUPPLY CO. P/N GP-211,  
CUT AS SHOWN AND INSTALL AFTER POWDER COAT  
(2 PLACES)

P/N	QTY. PER D3451				D1: HOLE SPACING
	-041	-043	-045	-047	
D3451-1	2	-	-	-	9.200
D3451-3	-	2	-	-	9.700
D3451-5	-	-	2	-	7.100
D3451-7	-	-	-	2	9.000



**SECTION A-A**

**D3451-041/-043/-045/-047 HANDLE & LOCK-DOWN ASS'Y**

**D3451-041 SUPERSEDES PREMIER P/N B67-43001-41**

**D3451-045 SUPERSEDES PREMIER P/N B67-43001-39**

**D3451-047 SUPERSEDES PREMIER P/N B67-43001-55**

**NOTES:**

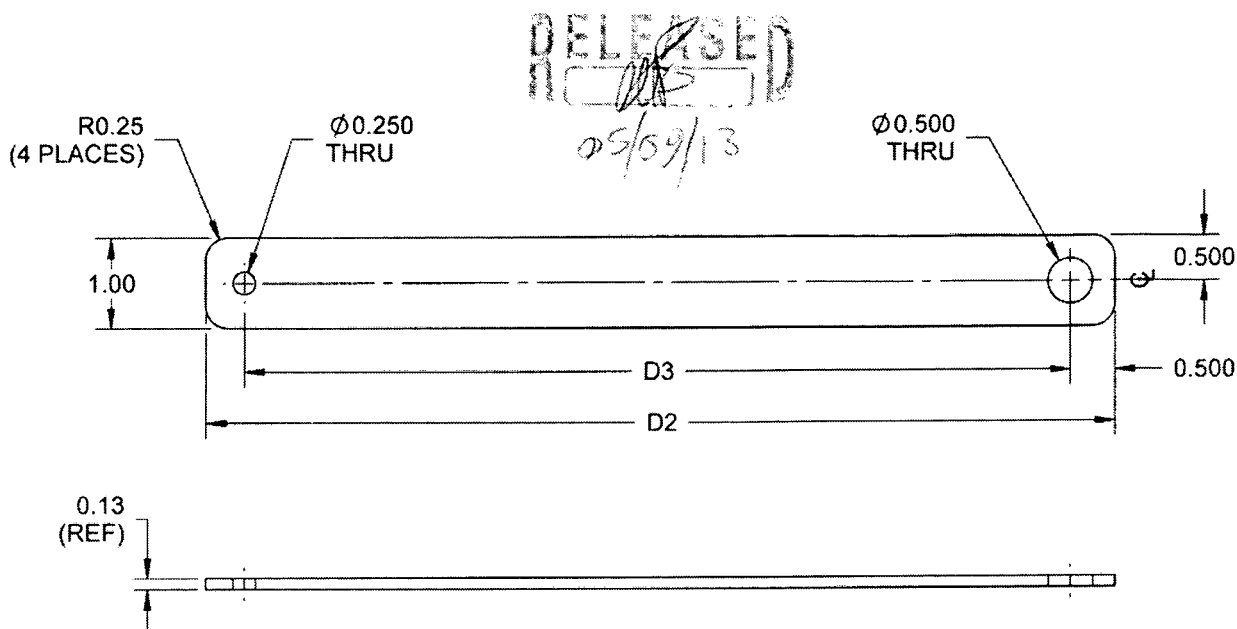
- 1) WELD PER DART QSI 004
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK BEFORE PAINTING.
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) PART IS SYMETRICAL ABOUT CENTER LINE.
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES
- 8) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3451	REV. A SHEET 2 OF 2
DATE 05.08.25		TITLE HANDLE & LOCK-DOWN ASS'Y	SCALE 1:2



P/N	D2: CUT LENGHT	D3: HOLE SPACING
D3451-1	10.25	9.200
D3451-3	10.63	9.700
D3451-5	8.00	7.100
D3451-7	10.00	9.000

#### **D3451-1/-3/-5/-7 TUBE HANDLE ARMS**

**D3451-1 SUPERSEDES PREMIER P/N B67-43001-303**  
**D3451-5 SUPERSEDES PREMIER P/N B67-43001-301**  
**D3451-7 SUPERSEDES PREMIER P/N B67-43001-101**

*42995*

#### **NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B0.125)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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